

Work Order ID 66437

Monday, February 14, 2011 1:33:57 PM



Page 1

Item ID: D4021-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 2/14/2011 Start Qty: 64.00



Cust Item ID:

Required Date: 2/18/2011 Req'd Qty: 64.00



Customer:

Reference:

Approvals:

Process Plan: *al*

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4021

B

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA 868 AND DWG D4021

DWG REV: *B*

FOLIO REV: _____

***MACHINE TO .375" MAX OD ***

DEBURR

al 11/2/24

64 *al*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

al 11/2/24

64 *al*

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Page 2

Item ID:	D4021-9	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bushing					
Start Date:	2/14/2011	Start Qty:	64.00	Cust Item ID:		
Required Date:	2/18/2011	Req'd Qty:	64.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		11.2-24		64			
130 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00		SAD 11-02-24		64			
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/02/24

ME
11-02-24

Picklist Print

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Work Order ID: 66437

Parent Item: D4021-9

Parent Item Name: Bushing



Start Date: 2/14/2011

Required Date: 2/18/2011

Start Qty: 64.00

Required Qty: 64.00

Comments: IPP REV:A NEW ISSUE 09-11-23 JLM VERIFIED BY:DD IPP
Rev:B as per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as
per dwg revB DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R 500 		Purchased	No			100	f	34.6440	0.083	5.591579			

304 SS roundbar 500

Location

Loc Qty

Loc Code

MAT

31.134

115334

31.134

MAT029

3.51

113006

3.51

116555


4.65 PA

11/21/24

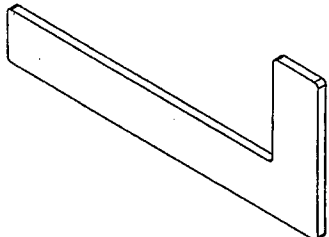
0.345
R.375
Jan 11-02-24

DART AEROSPACE LTD		Work Order:	60435
Description: Bushing		Part Number:	D4021-9
Inspection Dwg: D4021 Rev: B		Page 1 of 1	

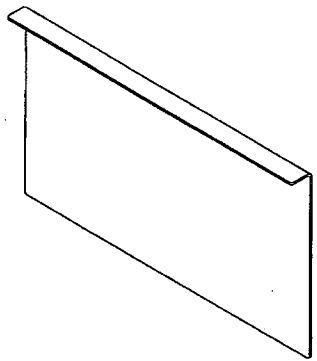
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Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	

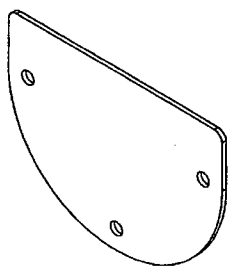
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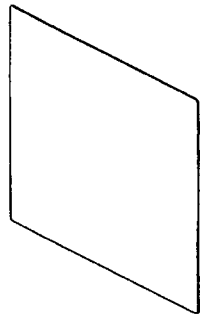
D4021-1 HANDLE PLATE



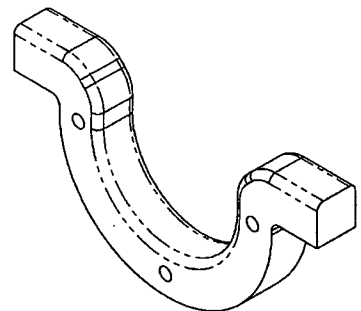
D4021-3 DATA PLATE



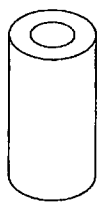
D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-7 HOOP



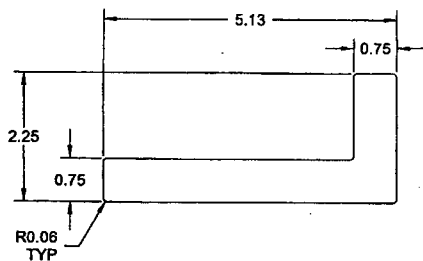
D4021-9 BUSHING

w/o 66437

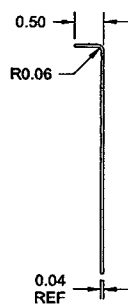
RELEASED
2010-04-14
MD

B	POWDER COAT SPEC ADDED TO NOTE 2 (A8-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	DRAWING NO. D4021	
DATE	10.04.06	TITLE MISC PARTS - 350 BASKET	
		REV. B SHEET 1 OF 3 SCALE NTS	
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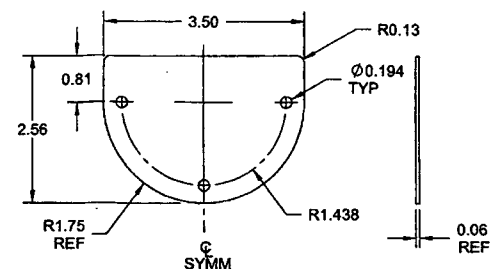
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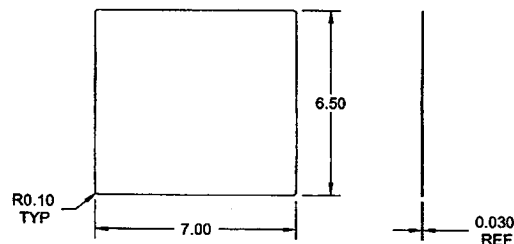
D4021-1 HANDLE PLATE



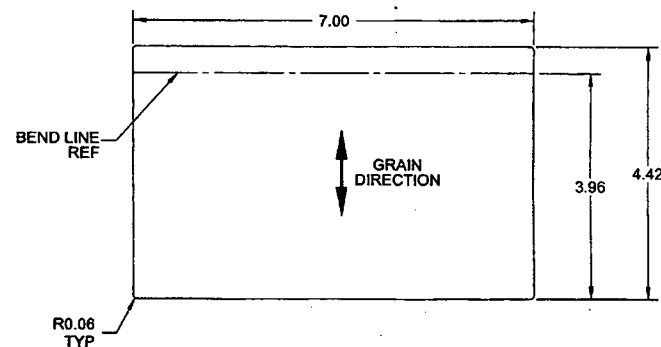
D4021-3 DATA PLATE
MAKE FROM D4021-3F



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-3F DATA PLATE
FLAT PATTERN

RELEASED
R 2010-04-14
NP

NOTES:

- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M303S16GA OR M304S16GA
- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S22GA

- 2) FINISH: -1/-3/-11: NONE
- 5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.18 lbs -3: 0.35 lbs
- 5: 0.14 lbs -11: 0.39 lbs

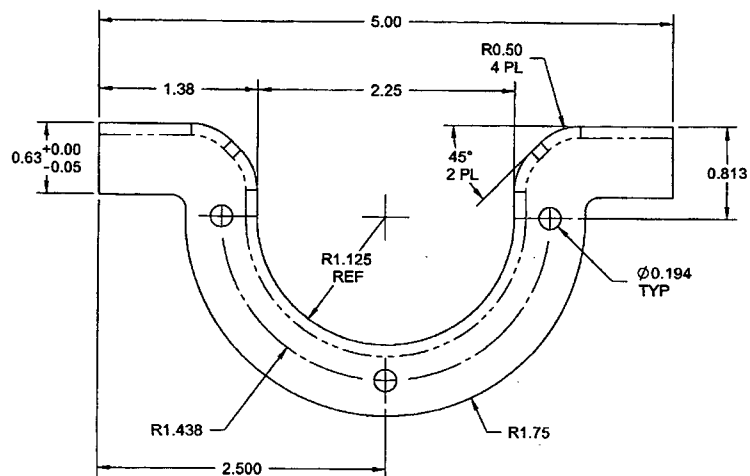
66437

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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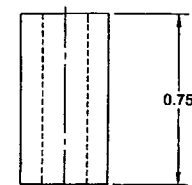
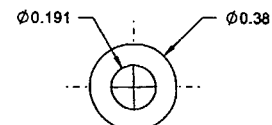
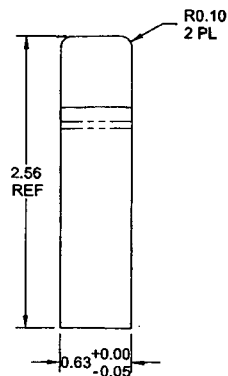
8 7 6 5 4 3 2 1

D

D



D4021-7 HOOP



D4021-9 BUSHING

NOTES:

1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT -7: 0.80 lbs

-9: 0.02 lbs

66437

RELEASED
2010-04-14
NR

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
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8 7 6 5 4 3 2 1

